

Date: Thursday, 9/11/2008 10:15:43 AM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ROUND BILLET, ALUMINUM
Job Number :	41965		
Estimate Number :	12286		
P.O. Number :		Part Number :	D6103003
This Issue :	9/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D6103 REV B
First Issue :	//	Project Number :	N/A
Previous Run :	41609	Drawing Revision :	B
	Type :	Material :	
	PURCHASED PARTS	Due Date :	9/26/2008
Written By :		Qty:	20
Checked & Approved By :		Um:	Each
Comment :	Est Rev:A New Issue 06-02-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 7144

a) Description: Alluminum round billet

b) Ø3.500" x 12.500" long

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Material: 7075-T7351 (QQ-A-225/9)

Material certification required

C 208/09/11

(20)

2.0	D6103003P	round alum billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 alum billet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C 8/9/22 (22)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

C 08/10/02

(22)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 8/9/22 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/11/2008 10:15:43 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ROUND BILLET, ALUMINUM

Job Number: 41965

Part Number: D6103003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/06 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

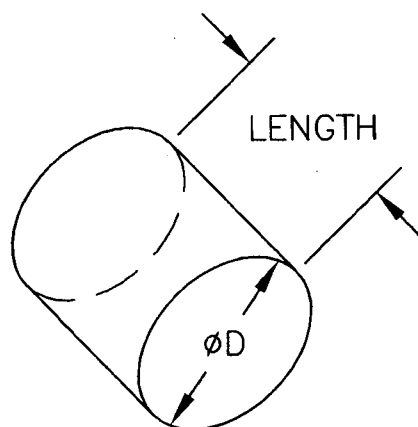


DESIGN <i>P41</i>	DRAWN BY <i>P41</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41965



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY,
DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

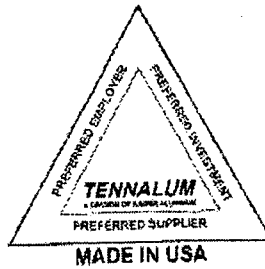
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KAISER ALUMINUM

FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

CUSTOMER PO NUMBER: 01-49436		CUSTOMER PART NUMBER: 21246		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 642472	LINE ITEM: 1	SHIP DATE: 09/09/2008	ALLOY: 7075	TEMPER: T651	
WEIGHT SHIPPED: 4077 lbs.	QUANTITY: 29 pcs.	B/L NUMBER: 28477	DIAM/DAF/THKNS: 3.500 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: A M Castle & Co 3400 No. Wolf Road Franklin Park, IL 60131 USA			SOLD TO: A M Castle & Co 3400 No. Wolf Road Franklin Park, IL 60131 USA		

Test Code: 1000 AC

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %
20108662	81.6	73.9	13.0
20109316	81.6	74.2	15.0

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.09	0.20	1.3	0.06	2.7	0.20	5.9	0.02			20108662
Actual	0.10	0.17	1.3	0.04	2.7	0.20	5.8	0.02			20109316
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Min			1.2		2.1	0.18	5.1				

Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4123H, AMS-QQ-A-225/9 Non-Standard: A97075-02-14

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

John Rennekamp

Plant Serial: 112735

Kaiser Order Number: 642472

Line Item: 1

IO. REQUISITION CLIENT-CUSTOMER REQUISITION NO.

NO. COM. CLIENT-CUST. ORD. NO.
7144COMPTÉ-ACCT.
91037VEND.-SLS
200TERR.
50EXPÉDIE PAR SHIP VIA
***** TRANSHIPMENT *****CHETEUR-PURCHASING AGENT
LINDA LACELLETELEPHONE
619 632-3336H/C
9 0TAXE
1 0NO. COM ORD
1REGION LIVRAISON-DEL ZONE
C/C

F.A.B.-F.O.B.

PREPAID

BILL

NO. FEVILE/EMBALLAGE B/L NUMBEI
1250139A-1

IVRE A-SHIP TO:

VENDU A-SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

INFORMATION CRÉDIT-CREDIT INFORMATION

ROUTE

01-NL-09/
30-NL-09/
31-NL-09/

INSTRUCTIONS/LIVRAISON-DELIVERY

***** TRANSHIPMENT *****

PRIOR DIST/ORD: 01 658647

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)
INQ-183655

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

DESCRIPTION - ITEM 1

3.5000 RD 7075-T651 ALUM BAR CF 12.50"

BLACK

QTE/UNITE COM.-ORDERED
22 PCSPCES/COM.ORD.
PCSPOIDS COM.-WT. ORDERED
26

BALLOTS-BUNDLES

PCES/PD EXP. SHP.

POIDS EXP.-WT. SHIPPED

11.640FT

FORME-SHAPE

I.A.C.

21246

ENT.-W

N12

***** CERTIFICATE OF CONFORMANCE *****

A.M. Castle & Co. certifies that the material(s) supplied
under this document will meet and conform to the
specifications of the product(s) described hereon.

A.M. Castle & Co. (Canada) Inc.

WEIGHT FOR SHIPPING PURPOSES ONLY. SEE
INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE
SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF
MATERIAL AND, IF CHECKED, TEST REPORTS.

INSTRUCTIONS

TOL + 1/8" - 0

CHICAGO:SHIP 2 FULL BARS

CUT IN MONTREAL

PRIOR DIST/ORD: 01 658647

COULÉE INFO-HEAT INFO QTE-QTY
20108662 ✓

INSTRUCTIONS (CONT'D.)

22 x 12.5"

DESCRIPTION - ITEM 2

**TERMS AND CONDITIONS
OF SALE**SEE DISCLAIMERS AND LIMITATIONS
ON THE REVERSE SIDE

INSTRUCTIONS

1 BOX

COULÉE INFO-HEAT INFO QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM.-ORDERED

PCES/COM.ORD.

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PD EXP. SHP.

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

ENT.-W

DESCRIPTION - ITEM 3

ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED
ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY
RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF
SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN
10 DAYS WHEN CREDIT IS REQUESTED.

INSTRUCTIONS

COULÉE INFO-HEAT INFO QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM.-ORDERED

PCES/COM.ORD.

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PD EXP. SHP.

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

ENT.-W

NOM (LETRE MOULEE)-NAME (PRINT ONLY)

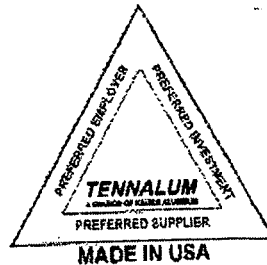
RECU PAR-RECEIVED BY

DATE RECU-
DATE RECEIVED

FEVILE D'EMBALLAGE - PACKING SLIP

**KAISER
ALUMINUM
FABRICATED PRODUCTS**

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. AS9100B:2004 This material meets the requirements of (cold finished) T6 temper, AMS 4122J and QQ-A-225/9E (CANCELLED). NAFTA - YES.

9/10/08
21246
(RM)

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John Rennekamp, Quality Manager

John Rennekamp

Plant Serial: 112735

Kaiser Order Number: 642472

Line Item: 1